

Work Order ID: ~~75089~~***75089***

Page 1

October-17-11 1:21:18 PM

Item ID: D3849-041

Accept

N9000040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: FWD WEARPLATE ASSY, STD/FLOOR GEAR

Start Date: 17/10/2011 Start Qty: 2.00

2

Cust Item ID:

Required Date: 04/11/2011 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: M.L.JDate: 11/10/17 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

- Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3849

B

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3849

Dwg Rev: BProg Rev: B

2-Deburr if necessary

B11-10-18

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B11-10-18

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

75089

Page 2

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Stop *NS2*

Start Date: 17/10/2011 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 04/11/2011 **Req'd Qty:** 2.00 ***~***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

[illegible]

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 75089

75089

Page 3

October-17-11 1:21:18 PM

Item ID: D3849-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: FWD WEARPLATE ASSY, STD/FLOAR GEAR
 Start Date: 17/10/2011 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 04/11/2011 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00				(2)	MAL	12/04/23	
150									
Large Fab	Memo	0.00							
Large Fab	1- On D3901-1 bar, fill cut outs with hardcoat welding rod as per dwg D3849 2059 B Hardcoat Welding Rod BATCH#: M121333								
	2- Weld D3901-1 bar to wearplate by positioning holes together as per dwg D3849 304 S.S. Welding Rod BATCH #: M120013								
160	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
160									
QC	Memo	0.00							
Quality Control									

2X Ø 12-04-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 75089

75089

Page 4

October-17-11 1:21:18 PM

Item ID: D3849-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: FWD WEARPLATE ASSY, STD/FLOAR GEAR
 Start Date: 17/10/2011 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 04/11/2011 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 *170* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<u>②</u>			
180 *180* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo START TIME: <u>10:20</u> OVEN TEMPERATURE: <u>320 °F</u> FINISH TIME: <u>10:50</u>	0.00 0.00				<u>2X</u> <u>✓</u>			<u>M-L</u> <u>12/04/24</u>
190 *190* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<u>2</u> <u>✓</u>			<u>12/24/24</u> <u>✓</u>

M117338

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 75089

75089

Page 5

October-17-11 1:21:18 PM

Item ID: D3849-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: FWD WEARPLATE ASSY, STD/FLOAR GEAR
 Start Date: 17/10/2011 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 04/11/2011 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200		0.00							
200						(x2)	Ø		Ac 12.04.24
Small Fab	Memo	0.00							
Small Fab	1- Bond D3848-1 gasket to inner surface of wearplate using a thin layer of 3m 1300/1300L scotch grip adhesive as per dwg BATCH: <u>m120954</u>								
210	QC5- Inspect part completeness to step on W/O	0.00							
210						(72)			
QC	Memo	0.00							
Quality Control									
220	Identify as per dwg & Stock Location: <u>FP</u>	0.00							
220						(20)	sf		shk
Packaging	Memo	0.00							
Packaging									

NOTED
10/10/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 75089***75089***

Page 6

October-17-11 1:21:18 PM

Item ID: D3849-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: FWD WEARPLATE ASSY, STD/FLOAR GEAR

Start Date: 17/10/2011 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 04/11/2011 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	QC21- Final Inspection - Work Order Release	0.00							
230									
QC	Memo	0.00							
Quality Control									

11/20/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October-17-11 1:21:23 PM

Page 1

Work Order ID: 75089

75089

Parent Item: D3849-041

D3849-041

Parent Item Name: FWD WEARPLATE ASSY, STD/FLOAR GEAR

Start Date: 17/10/2011

Required Date: 04/11/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3848-1 *D3848-1* GASKET		Manufactured	No				Each	6.0000		2			
									**			<i>Ac 12.04.24</i>	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FP013				6				<i>(2)</i>	
				<u>52530</u>				6					
D3901-1 *D3901-1* Bar		Manufactured	No				Each	0.0000					
									**			<i>(x2) MAL 12/04/23</i>	
M304S18GA *M304S18GA* 304/316 .050 Sheet		Purchased	No				sf	264.3050		5.157895			
									**			<i>B11-10-18</i>	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		<i>(2)</i>	
				MAT020				264.305					
				113062				0.005					
				118217				0.5					
				119032				206.8				<i>119032</i>	
				119188				57					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	750 89
Description: Wearplate		Part Number:	D3849-1
Inspection Dwg: D3849	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.188	+0.005/-0.001	.190	✓		V B02	
Ø0.375	+0.006/-0.001	.376	✓		V	
5.89	+/-0.030	5.89	✓		T B01	
18.000	+/-0.010	18.000	✓		T	
36.000	+/-0.010	36.000	✓		T	
51.313	+/-0.010	51.313	✓		T	
2.45	+/-0.030	2.45	✓		T	
2.433	+/-0.010	2.441	✓		✓	
6.642	+/-0.010	6.640	✓		T	
4.38	+/-0.030	4.38	✓		V	
7.00	+/-0.030	7.00	✓		T	
4.00	+/-0.030	4.00	✓		T	
34.500	+/-0.010	34.500	✓		T	
54.26	+/-0.030	54.26	✓		T	
7.72	+/-0.030	7.724	✓		V	
0.050	+/-0.010	.051	✓		V	

Measured by: B	Audited by: [Signature]	Prototype Approval:	N/A
Date: 11-10-19	Date: 11-10-31	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.10.01	New Issue	KJ	[Signature]

P/O D3849-041

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

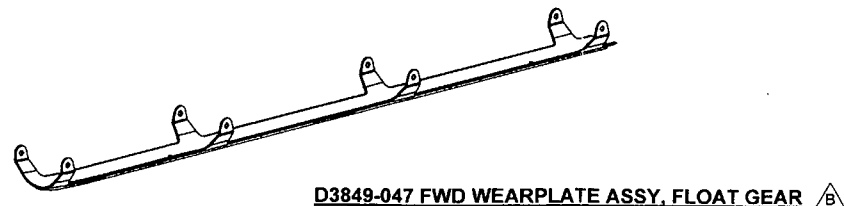
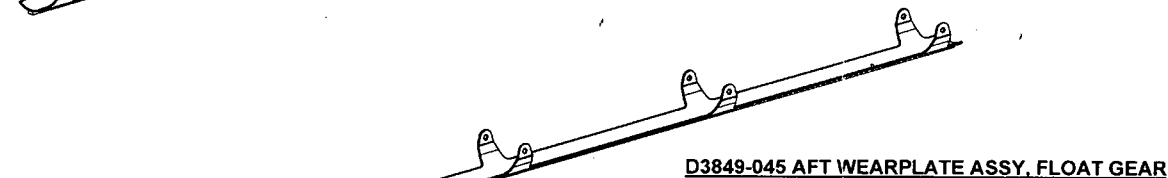
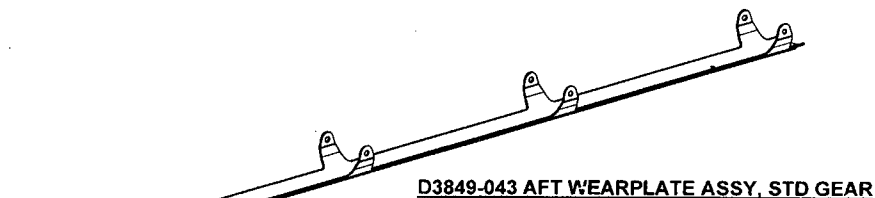
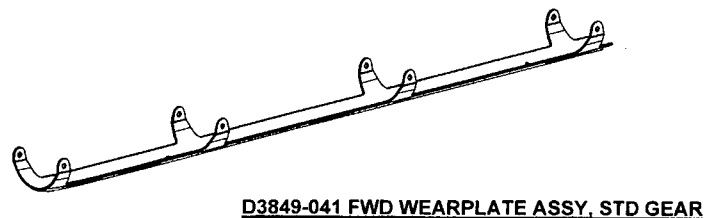
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3849-041	FWD WEARPLATE ASSY, STD GEAR
2		X			D3849-043	AFT WEARPLATE ASSY, STD GEAR
3			X		D3849-045	AFT WEARPLATE ASSY, FLOAT GEAR
4				X	D3849-047	FWD WEARPLATE ASSY, FLOAT GEAR
11	1				D3849-1	PLATE
12		1			D3849-3	PLATE
13			1		D3849-5	PLATE
14				1	D3849-7	PLATE
15	1				D3848-1	GASKET
16		1			D3848-3	GASKET
17			1		D3848-5	GASKET
18				1	D3848-7	GASKET
19	1			1	D3901-1	BAR
20		1			D3901-3	BAR
21			1		D3901-5	BAR
31	A/R	A/R	A/R	A/R	2059B	HARDCOAT
32	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 75089 M.L.J.
11/10/17

RELEASED
11/10/17

B	REVISED FLAT PATTERN @ 0.375 WAS SLOT HOLE ON D3849-17; 3F1-5F (ZN A4-5 B4-7, B4-8, C2-10, B2-10); ADD D3849-047 (ZN D4-1, A4-1 & B4-5) & D3849-7; 7F (ZN C4-9, A4-9); ADD SECTION K-K (ZN C5-10); 0.88 WAS 0.875 & 0.44 WAS 0.438 (ZN A3-10); ADD 0.25 & 0.88 (ZN D4-10, D3-10); ADD 0.88 & 0.14 (ZN C3-10 & B3-10); ADD FLAG NOTE (ZN A8-2, C6-2, C3-2, A8-3, C6-3, C3-3, A8-4, C6-4, C2-4); 66.87 WAS 67.35 (ZN B4-7)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	ED	D3849	SHEET 1 OF 10
APPROVED	AW	TITLE	SCALE
DE APPR.	H	WEARPLATE ASSY	NTS
DATE	09.06.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

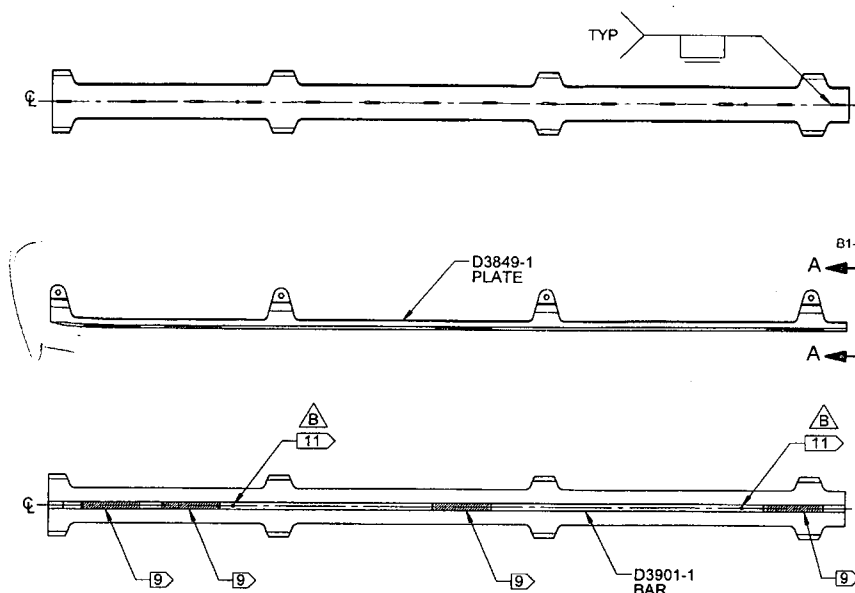
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

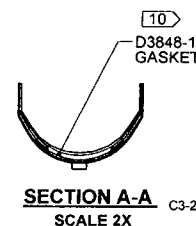
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NOTE: Date & initial all entries

75089



D3849-041 FWD WEARPLATE ASSY. STD/FLOAT GEAR



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3849-041" USING YELLOW PAINT MARKER AT INSIDE SURFACE
- 7) WEIGHT: D3849-041 = 4.24 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D3901-1 BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3848-1 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE
- 11) TRANSFER DRILL $\varnothing 0.188$ HOLES FROM D3849-1 PLATE TO D3901-1 BAR



DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3849	SHEET 2 OF 10
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
DATE	09.06.30	<small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
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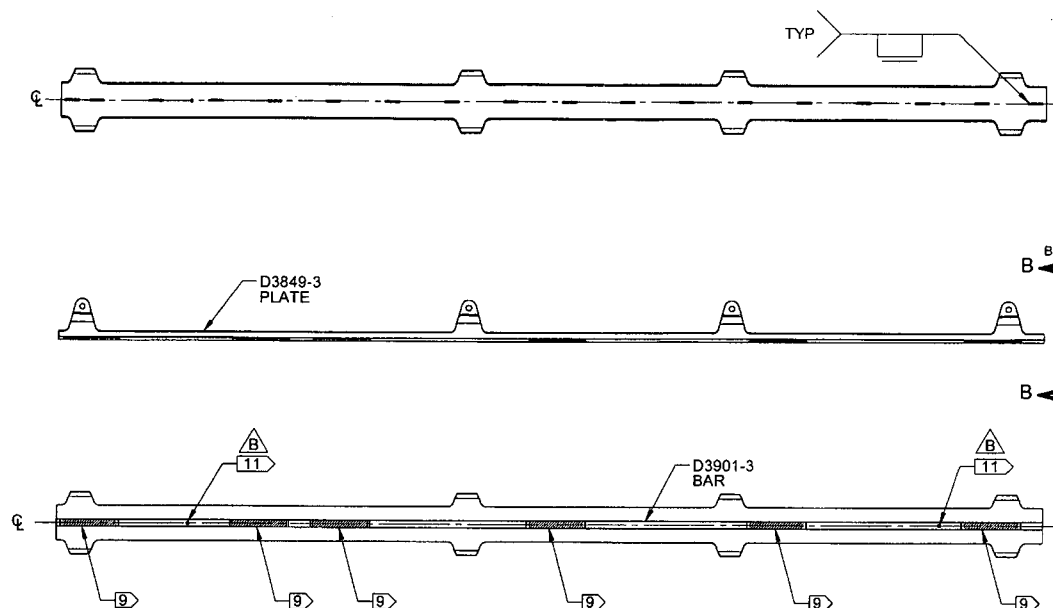
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NOTE: Date & initial all entries

75089



D3849-043 AFT WEARPLATE ASSY, STD GEAR

SECTION B-B C2-3
SCALE 2X

RELEASED
9/27/13

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3849-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3849-043 = 5.21 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D3901-3 BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3848-3 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE
- 11) TRANSFER DRILL $\varnothing 0.188$ HOLES FROM D3849-3 PLATE TO D3901-3 BAR

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3849	SHEET 3 OF 10
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	WEARPLATE ASSY	NTS
DATE	09.06.30	<small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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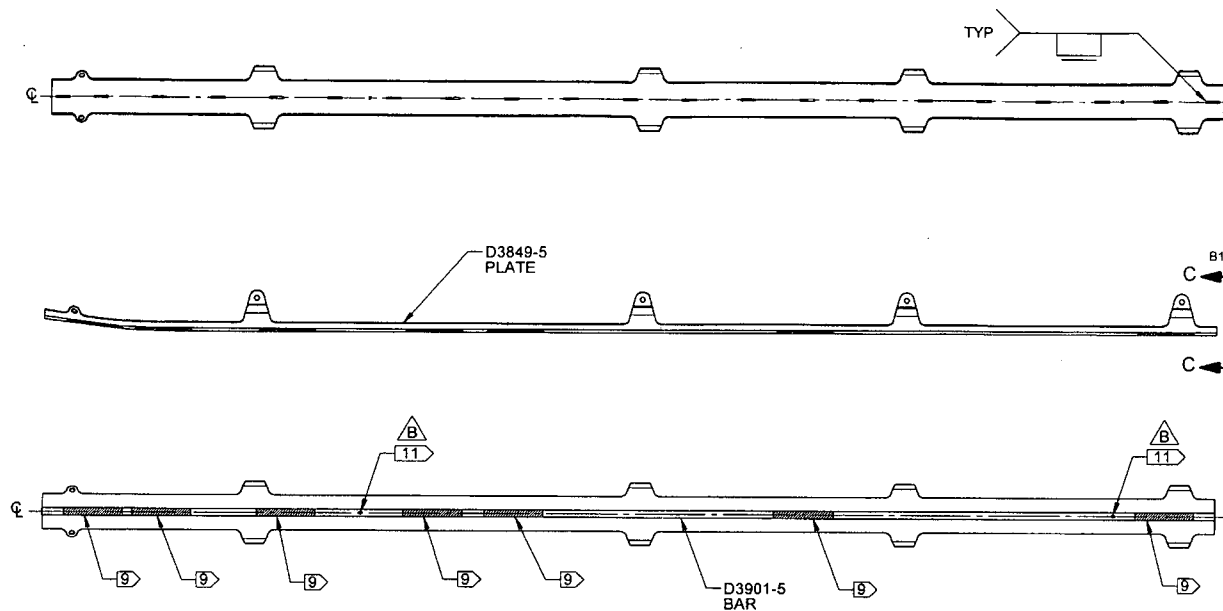
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D3849-045 AFT WEARPLATE ASSY, FLOAT GEAR

SECTION C-C C2-4
SCALE 2X

RELEASED
09/15/15

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3849-045" USING YELLOW PAINT MARKER AT INSIDE SURFACE
- 7) WEIGHT: D3849-045 = 5.98 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D3849-5 BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3848-5 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE
- 11) TRANSFER DRILL $\varnothing 0.188$ HOLES FROM D3849-5 PLATE TO D3901-5 BAR

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3849	SHEET 4 OF 10
APPROVED	JAN 11	TITLE	SCALE
DE APPR.	RF	WEARPLATE ASSY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

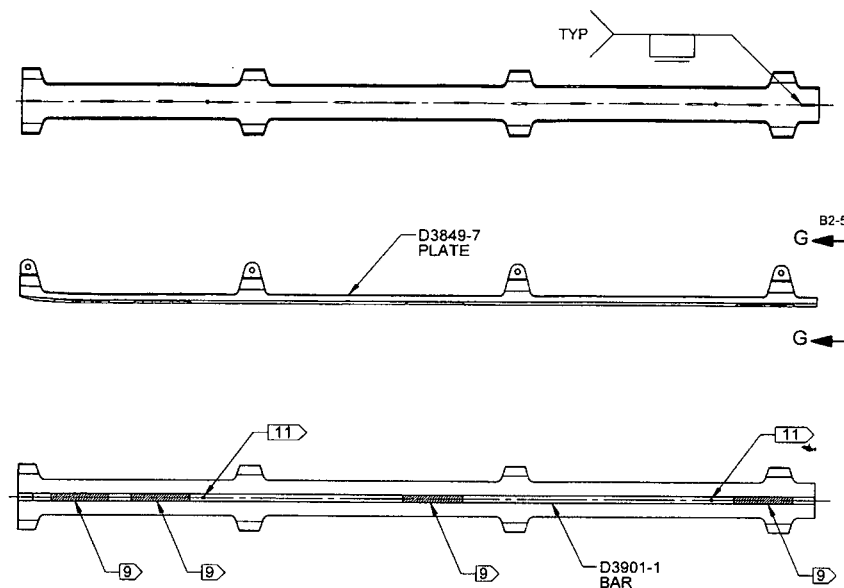
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

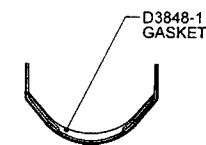
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

75089



D3849-047 FWD WEARPLATE ASSY, FLOAT GEAR



SECTION G-G C3-5
SCALE 2X

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3849-047" USING YELLOW PAINT MARKER AT INSIDE SURFACE
- 7) WEIGHT: D3849-047 = 4.26 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D3901-1 BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3848-7 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE
- 11) TRANSFER DRILL $\varnothing 0.188$ HOLES FROM D3849-7 PLATE TO D3901-1 BAR

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D3849	REV. B
MFG. APPR.	RF	SHEET 5 OF 10	
APPROVED	RF	TITLE WEARPLATE ASSY	SCALE NTS
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DATE	09.06.30		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

750 89

0.3 REF

R38.5

49.51

D3849-1 PLATE
(MAKE FROM D3849-1F)

A5-10

0.050
REF
 Δ B
7.72

 Δ B
5.89

 ϕ 0.188 THRU
2 PL

 Δ B
51.313

 Δ B
36.000

 Δ B
18.000

 Δ B
2.45

 Δ B
2.433
TYP

 Δ B
6.642
4 PL

 Δ B
4.38

 Δ B
7.00

 Δ B
54.26 REF

 Δ B
4.00
TYP

 Δ B
R0.38
TYP

 Δ B
R0.50
TYP

 Δ B
105°
TYP

 Δ B
R0.06
2 PL

 Δ B
C2-10
DETAIL G

 Δ B
A3-10
DETAIL F

 Δ B
C3-10
DETAIL H

D3849-1F FLAT PATTERN Δ B

RELEASED
09/15/14

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.33 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, VA	
CHECKED	<i>RF</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>RF</i>	D3849	SHEET 6 OF 10
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	WEARPLATE ASSY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

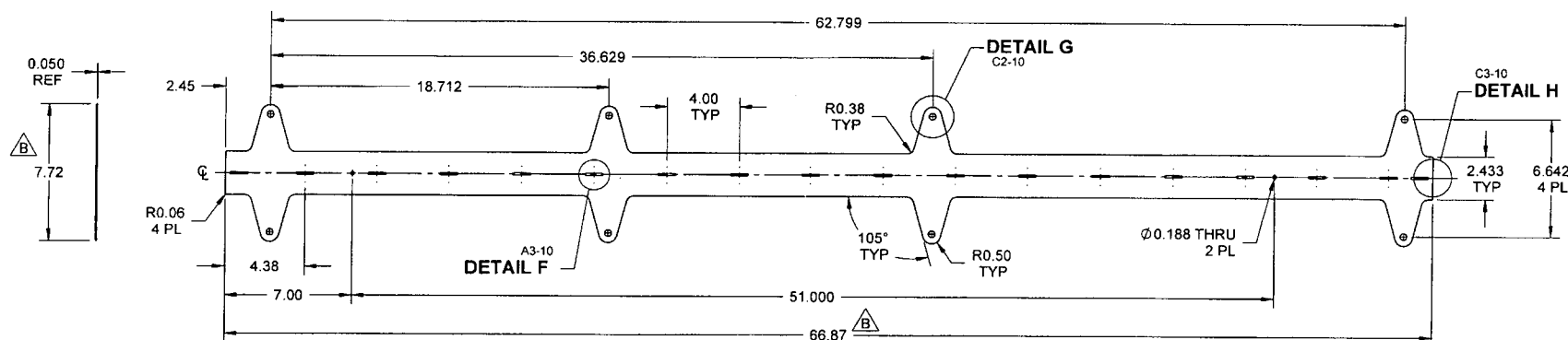
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

75089



D3849-3 PLATE
(MAKE FROM D3849-3F)



D3849-3F FLAT PATTERN \triangle

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.82 lbs

RELEASED
10/6/15/11

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	AW	DRAWING NO.	REV. B
MFG. APPR.	AW	D3849	SHEET 7 OF 10
APPROVED	AW	TITLE	SCALE
DE APPR.	AW	WEARPLATE ASSY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

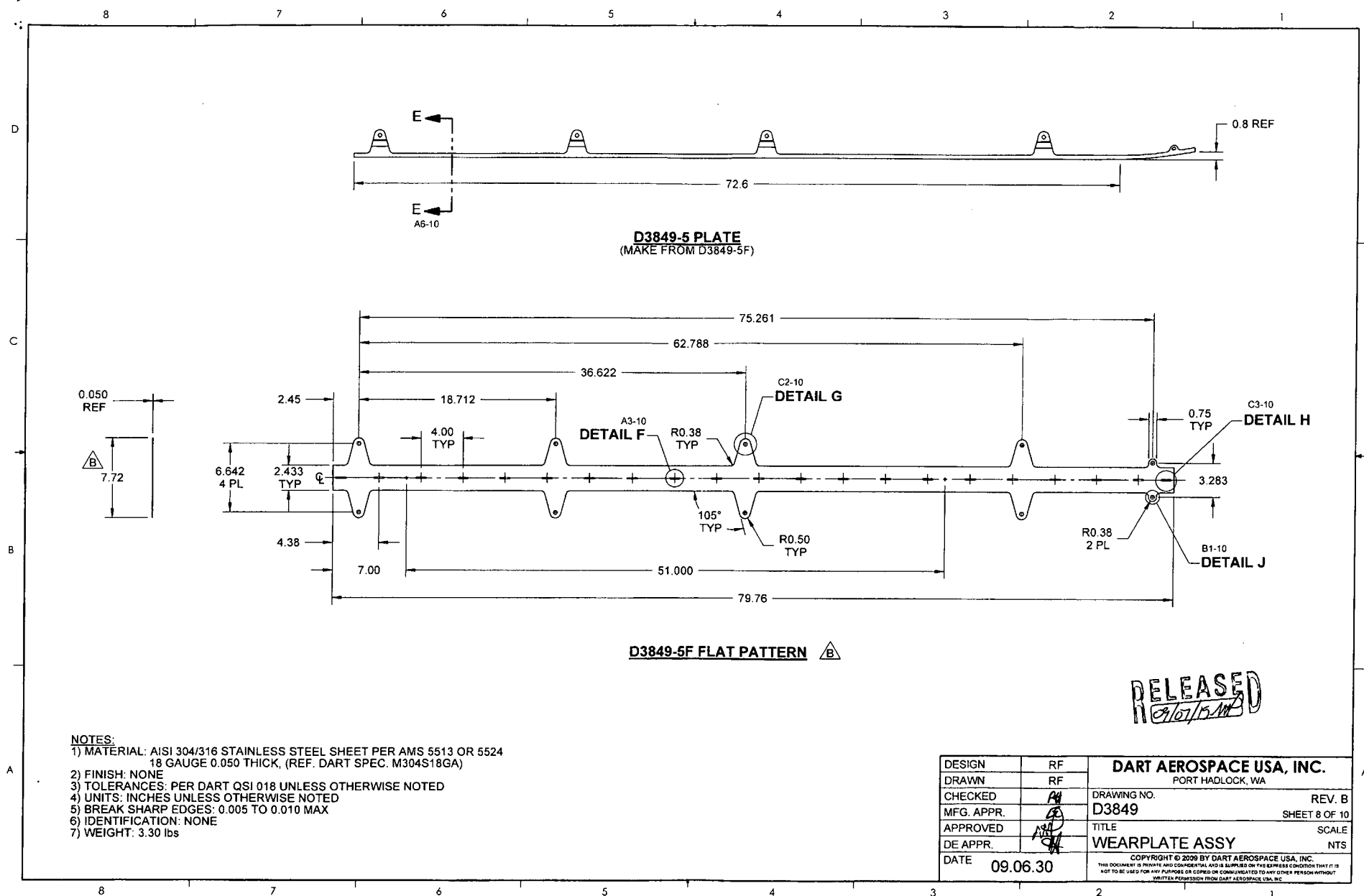
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

75089



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

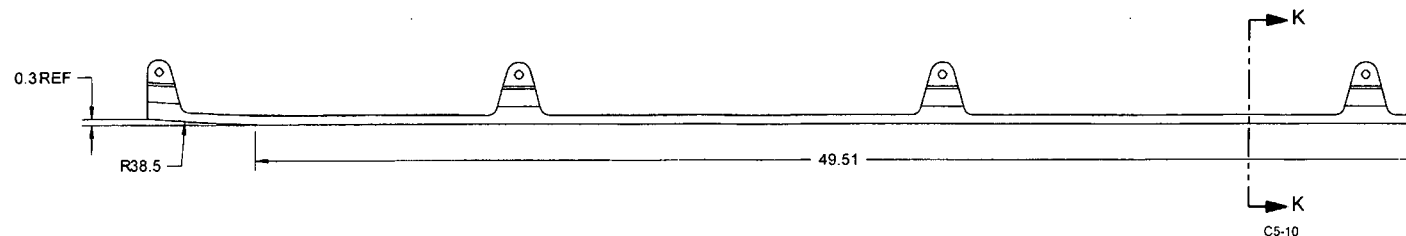
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

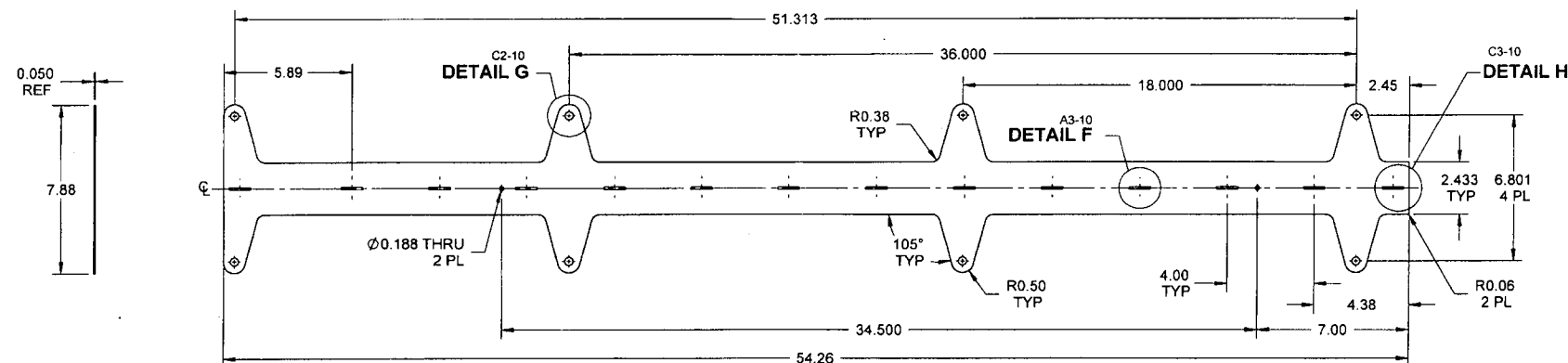
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

75089



D3849-7 PLATE
(MAKE FROM D3849-7F)



D3849-7F FLAT PATTERN

RELEASED
09/07/15

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.34 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	CE	D3849	SHEET 9 OF 10
APPROVED	AW	TITLE	SCALE
DE APPR.	AW	WEARPLATE ASSY	NTS
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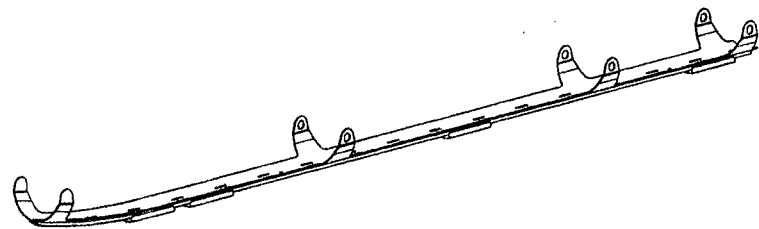
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

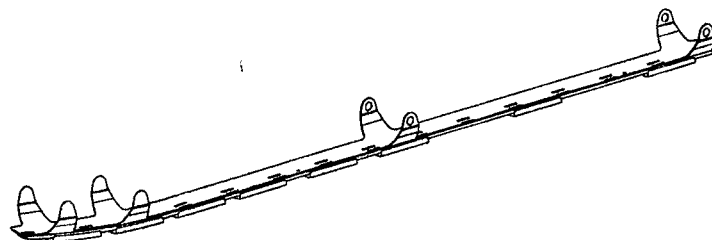
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4406-041 FWD WEARPLATE ASSY



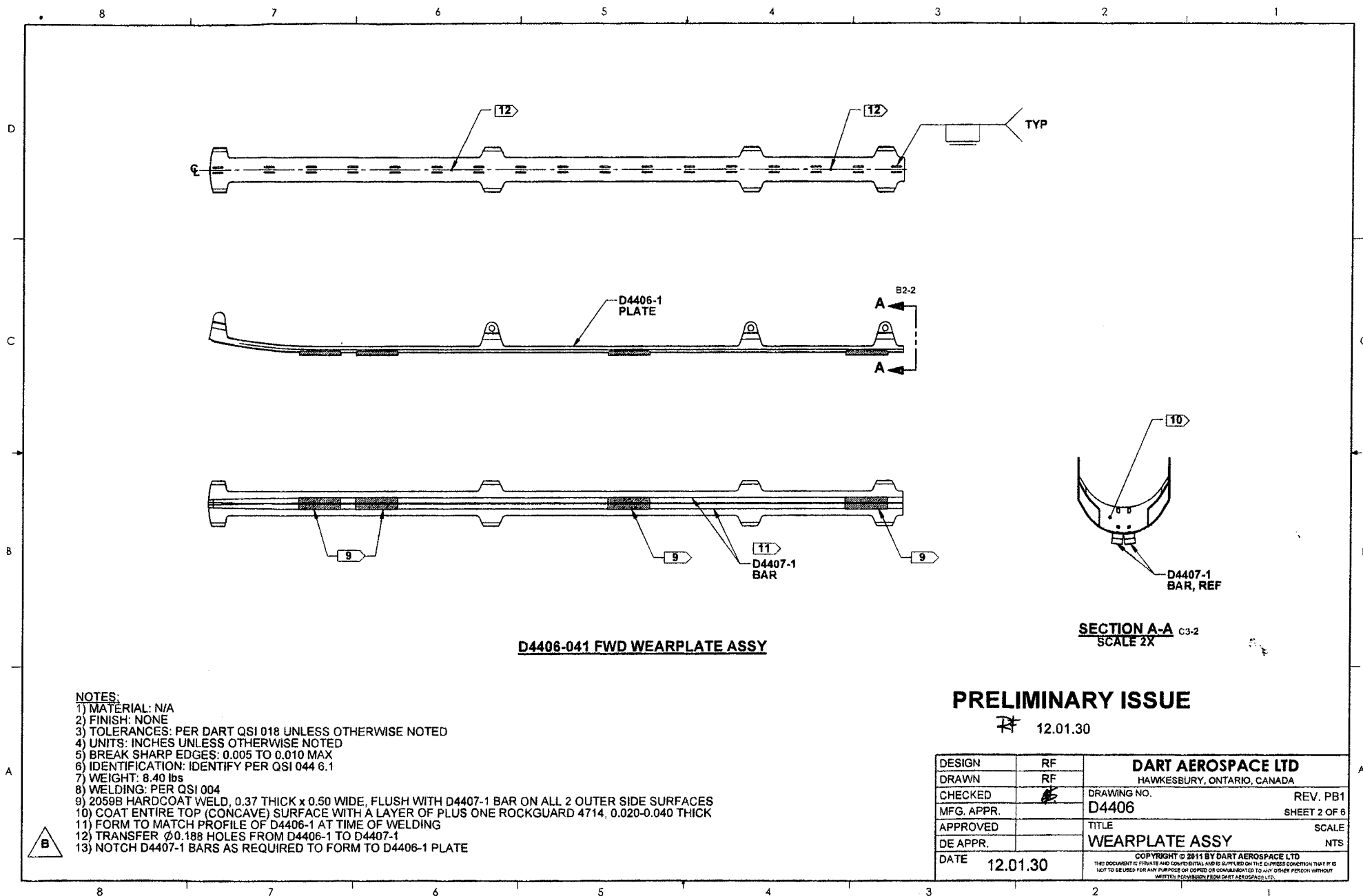
D4406-043 AFT WEARPLATE ASSY

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D4406-041	FWD WEARPLATE ASSY
2		X	D4406-043	AFT WEARPLATE ASSY
3	1		D4406-1	PLATE
4		1	D4406-3	PLATE
5	2		D4407-1	BAR
6		2	D4407-3	BAR
7	A/R	A/R	2059B	HARDCOAT
8	A/R	A/R	4714	PLUS ONE ROCKGUARD (SEE NOTE 10, SHT 2 & 3)

PRELIMINARY ISSUE

~~12~~ 12.01.30

PB1	REVISE BILL MATERIAL; ADD NOTE 13/14; REVISE NOTE 9; MODIFY NOTCHES; -1F REMOVED 2 TAB HOLES; -3F REMOVED 4 TAB HOLES		RF	12.01.30
A	NEW ISSUE		RF	11.08.15
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4406 REV. PB1 WEARPLATE ASSY SCALE NTS COPYRIGHT © 2011 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		
DRAWN	RF			
CHECKED	RF			
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	12.01.30			



D4406-041 FWD WEARPLATE ASSY

SECTION A-A C3-2
SCALE 2X

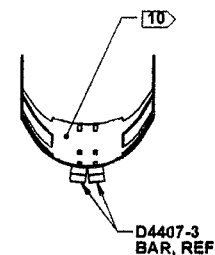
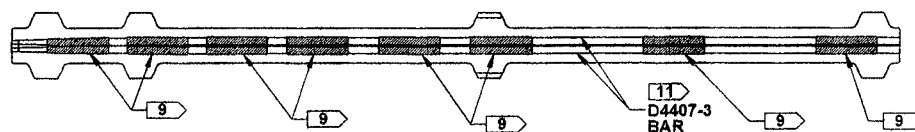
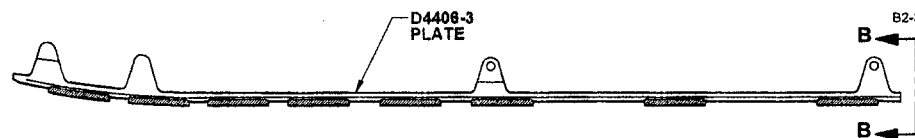
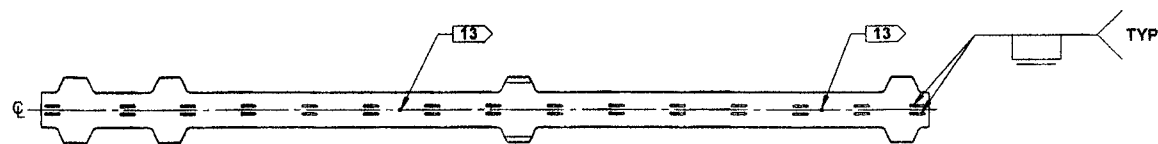
PRELIMINARY ISSUE

12.01.30

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 8.40 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.37 THICK x 0.50 WIDE, FLUSH WITH D4407-1 BAR ON ALL 2 OUTER SIDE SURFACES
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 11) FORM TO MATCH PROFILE OF D4406-1 AT TIME OF WELDING
- 12) TRANSFER Ø0.188 HOLES FROM D4406-1 TO D4407-1
- 13) NOTCH D4407-1 BARS AS REQUIRED TO FORM TO D4406-1 PLATE

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D4406	REV. PB1
MFG. APPR.			SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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D4406-043 AFT WEARPLATE ASSY


SECTION B-B C3-3
SCALE 2X

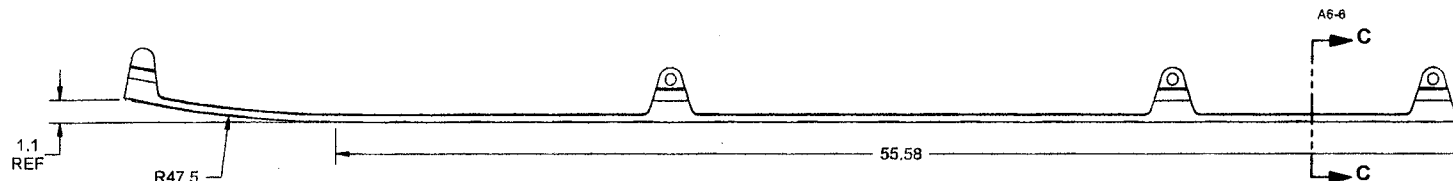
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 8.76 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.37 THICK x 0.50 WIDE, FLUSH WITH D4407-3 BAR ON ALL 2 OUTER SIDE SURFACES
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 11) FORM TO MATCH PROFILE OF D4406-3 AT TIME OF WELDING
- 12) FILL TOOLING HOLE WITH WELD ONE PLACE ONLY
- 13) TRANSFER $\phi 0.188$ HOLES FROM D4406-3 TO D4407-3
- 14) NOTCH D4407-3 BARS AS REQUIRED TO FORM D4406-3 PLATE

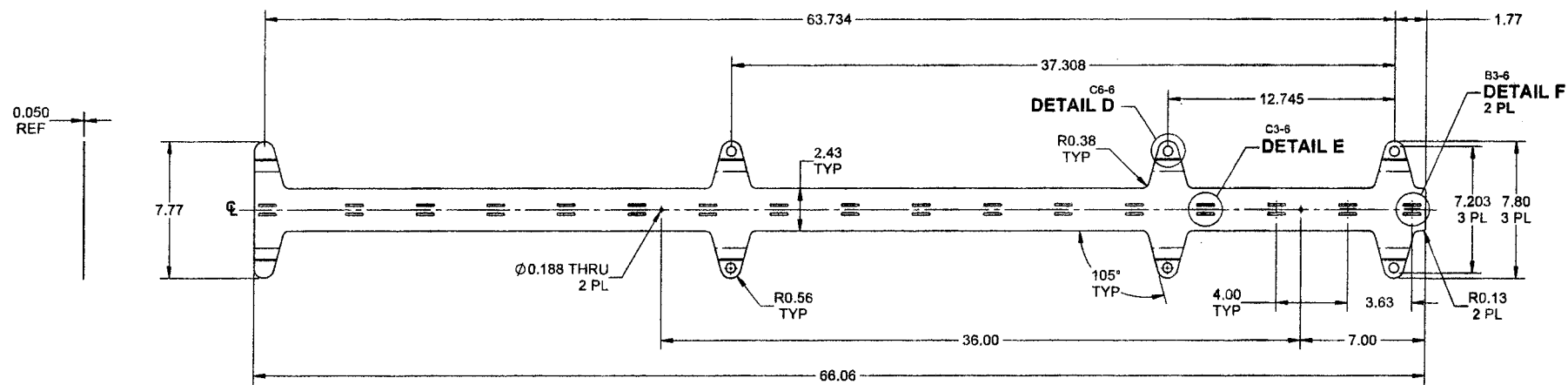
PRELIMINARY ISSUE

12.01.30

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESSBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PB1
MFG. APPR.		D4406	SHEET 3 OF 6
APPROVED		TITLE	SCALE
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D4406-1 PLATE
(MAKE FROM D4406-1F)



D4406-1F FLAT PATTERN

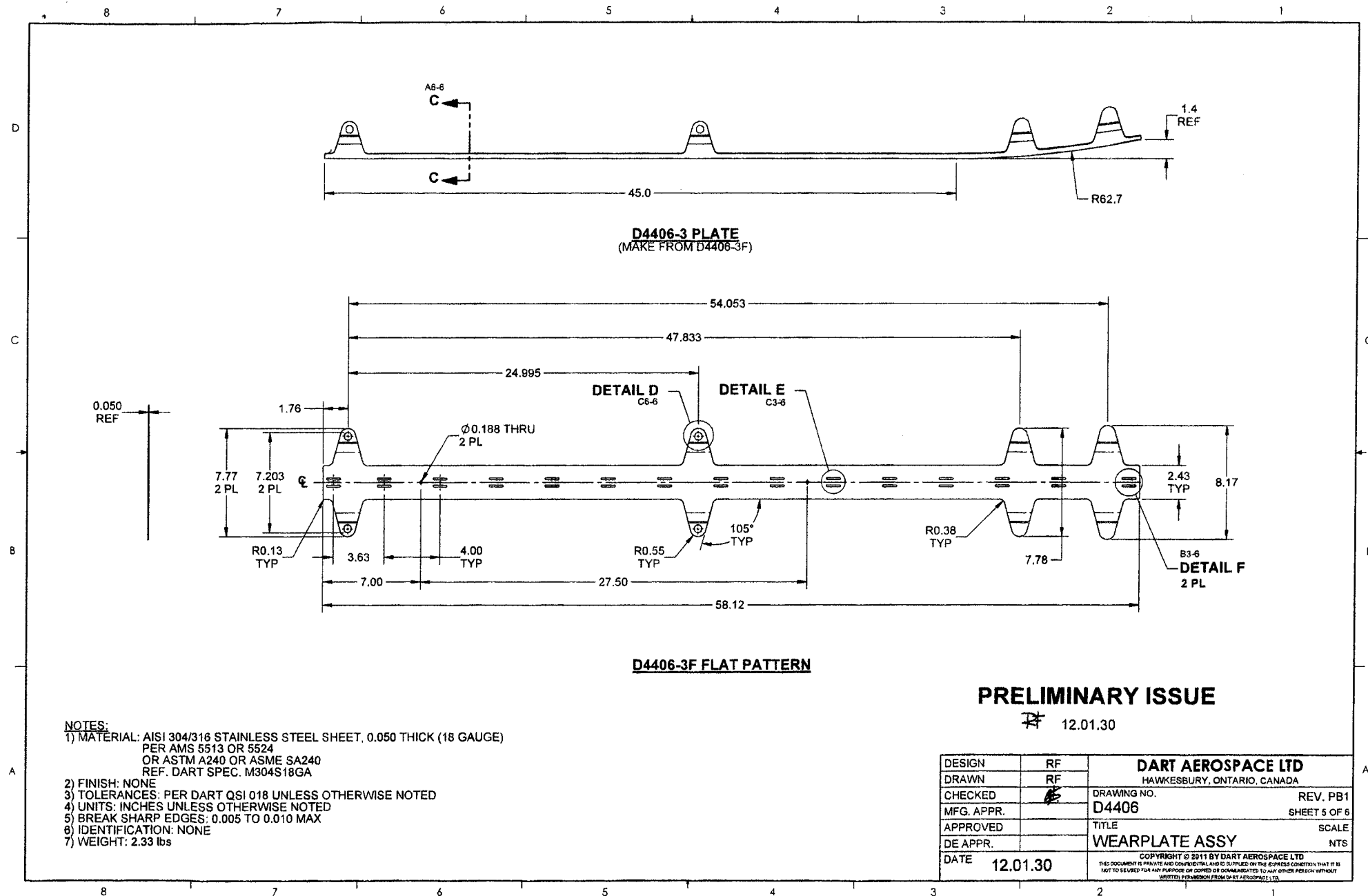
PRELIMINARY ISSUE

~~12~~ 12.01.30

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.050 THICK (18 GAUGE)
PER AMS 5513 OR 5524
OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.33 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D4406	REV. PB1
MFG. APPR.			SHEET 4 OF 8
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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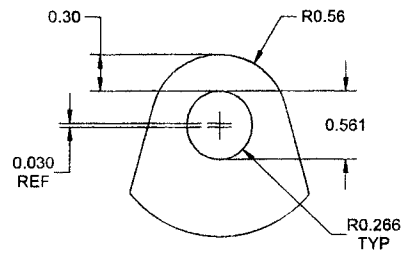
PRELIMINARY ISSUE

~~12~~ 12.01.30

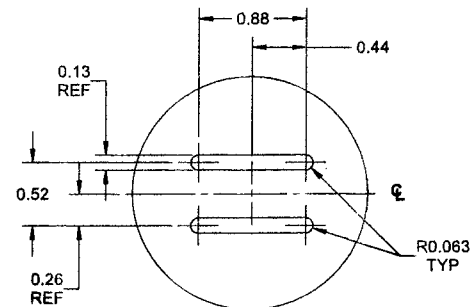
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.050 THICK (18 GAUGE)
PER AMS 5513 OR 5524
OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.33 lbs

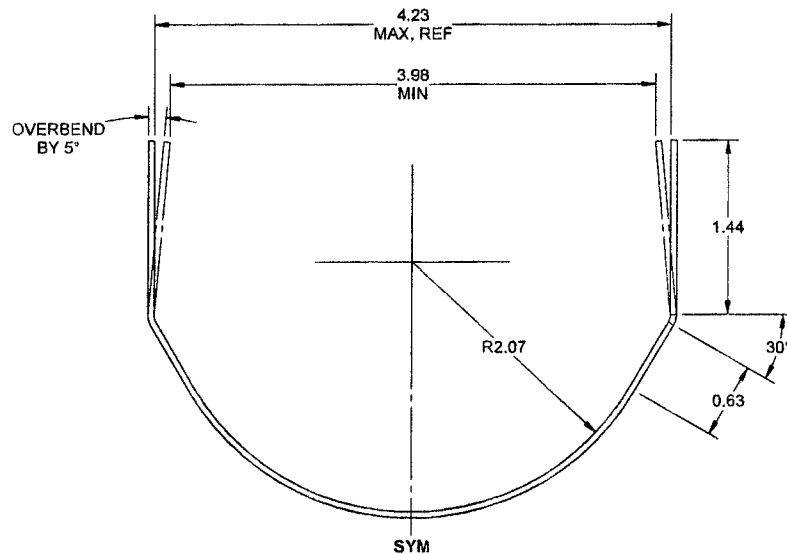
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. PB
MFG. APPR.		D4406	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NT
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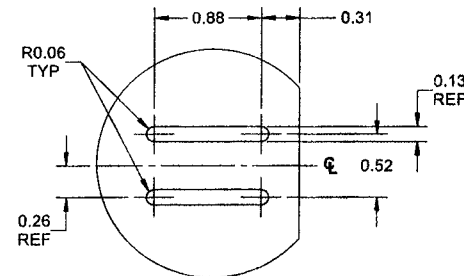
DETAIL D
SLOT DETAIL TYP
SCALE 6X



DETAIL E
SLOT DETAIL TYP
SCALE 6X




DETAIL C
DETAIL TYP
SCALE 6X



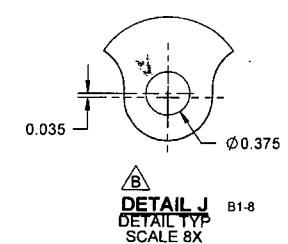
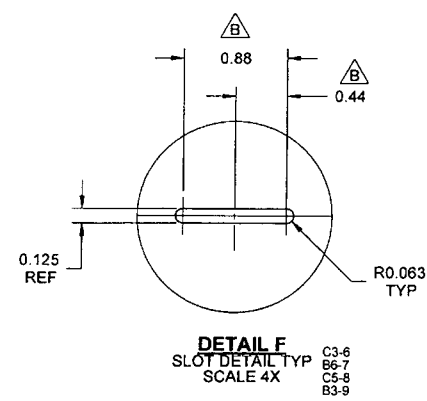
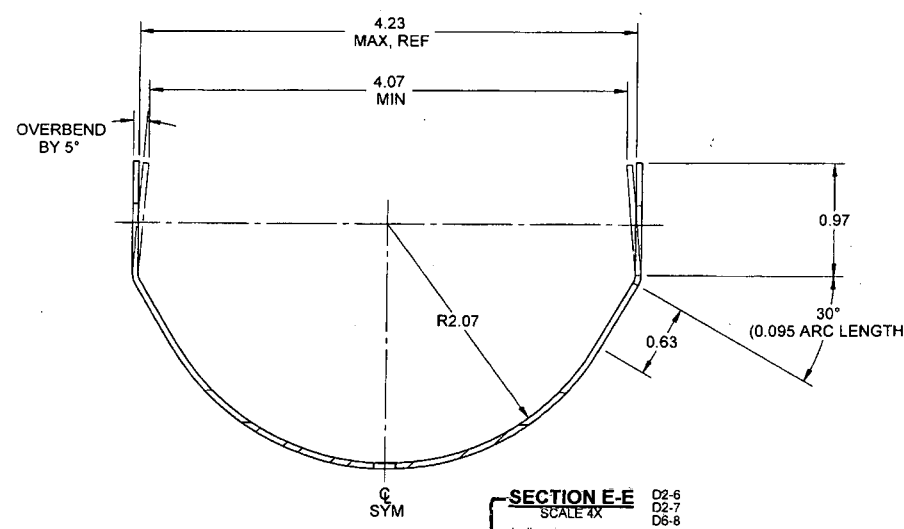
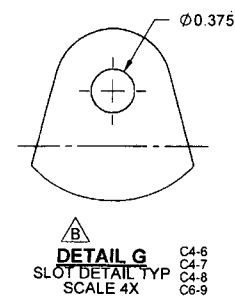
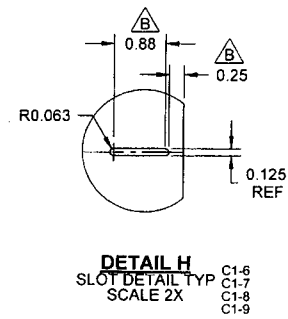
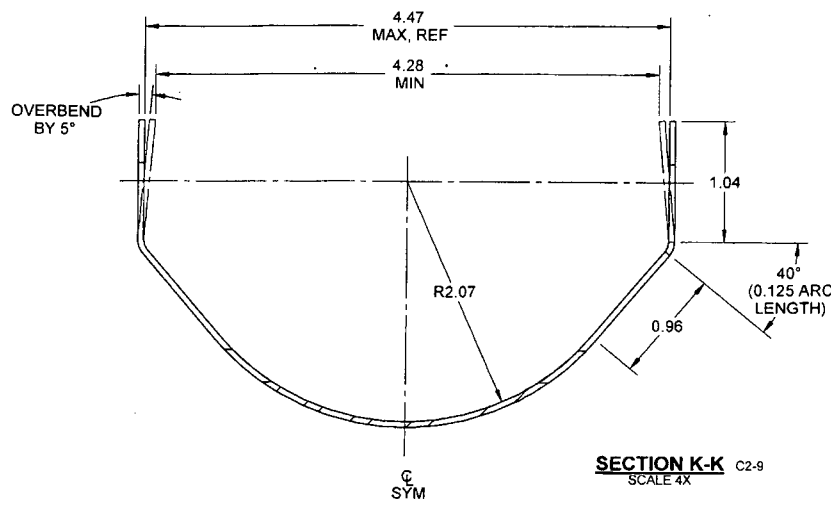
DETAIL F
SLOT DETAIL TYP
SCALE 6X

PRELIMINARY ISSUE

12.01.30

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PB1
MFG. APPR.		D4406	SHEET 6 OF 6
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09/07/15

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG APPR.		D3849	SHEET 10 OF 10
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries